

Work Order ID 51133

August 4, 2009 11:41:50 AM



Page 1

Item ID: D3512-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Wearplate

Start Date: 8/05/09 Start Qty: 6.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: *W*

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3512	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3512 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

B 9-8-4

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-8-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8 08/08/04

(B) 9-8-4

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Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr if necessary ☐ Form as per dwg D3512 using DT8179

EP 09/08/05 (10)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8/02/05

(40) f

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004 ☐ Qty
Description Batch ☐ A/R 2059b Hardcoat Rod *M12372*

EL

9-8-6

(X10)

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Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

QC10- Inspect visual per QSI004- ground welds

0.00

=> 8/08/06

(10)

φ



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

=> 8/08/06

(10)

φ



QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M109091



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:45pm OVEN TEMPERATURE:

12:15pm FINISH TIME:

370°F

=1

09-08-06

(10)

SEP

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Required Date: 8/14/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190 QC3- Inspect Part Finish

0.00



QC Memo

0.00

Quality Control

BF 09-08-06

(D)

200 Identify as per dwg & Stock Location: 300

0.00



Packaging Memo

0.00

Packaging

9/8/7

(10x) 50

210 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

09-08-11

MF 09-08-07

Picklist Print

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Work Order ID: 51133

Parent Item: D3512-1RevC

Parent Item Name: Wearplate

Comments:

Start Date: 8/05/09

Required Date: 8/14/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	263.4130	1.6484	10		

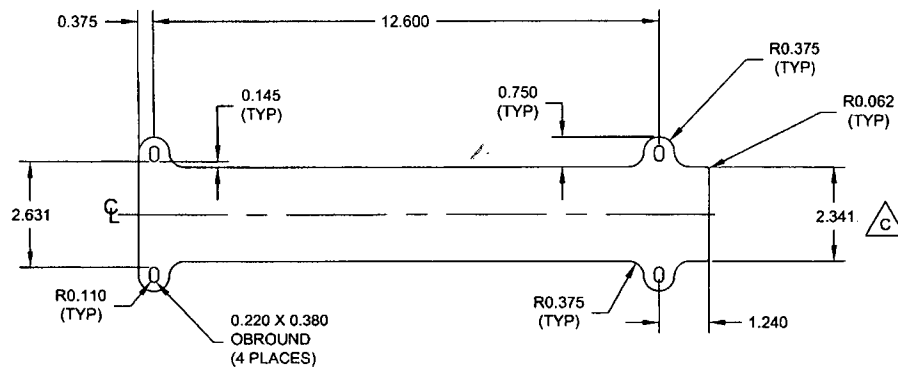
304/316 Sheet .063

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	263.4129737	
106860	17	
111924	54.4129737	
112290	192	

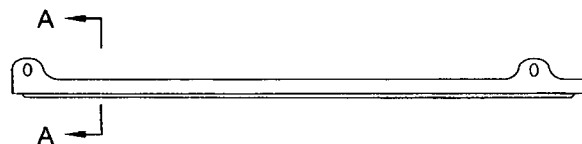
11924

B 9-8-4

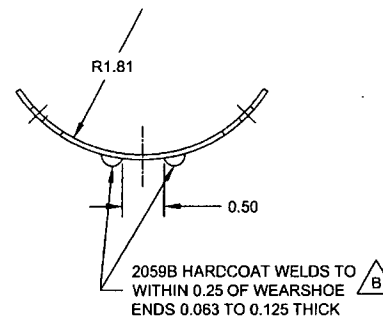
10



D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A
SCALE 2:3

RELEASED
07-11-16 1027



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		
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